

Date: Wednesday, 4/4/2007 9:03:32 AM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: BASKET HINGE
Job Number	: 31608		
Estimate Number	: 10587		
P.O. Number	: <u>NIA</u>	Part Number	: D22321
This Issue	: 4/4/2007 S.O. No. : <u>NIA</u>	Drawing Number	: D2232 REV C
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <u>NIA</u> Type : SMALL /MED FAB	Drawing Revision	: C
Previous Run	: 29535	Material	: <u>NIA</u>
Written By	: <u>4/07.04.04</u>	Due Date	: 4/30/2007
Checked & Approved By	: <u>4/07.04.04</u>	Qty:	50 Um: Each
Comment	: Est.B 01/06/07 Now laser cut EC Est Rev:C Now on Waterjet 06-11-21 JLM		

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	M304S11GA	304/316 .125 Sheet
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Comment: Qty.: 0.0255 sf(s)/Unit Total : 1.2758 sf(s)
 304/316 .125 Sheet

M 102807

ml 07/04/25 (50)

2.0	WATER JET	FLOW WATER JET
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Comment: FLOW WATER JET
 1-Cut as per Dwg D2232
 Dwg Rev: C
 Prog Rev: C

2-Deburr if necessary

ml 07/04/25 (50)
07/05/03 (49)

3.0	QC2	INSPECT PARTS AS THEY COME OFF MACHINE
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ml 07 04 25

(50)

Comment: INSPECT PARTS AS THEY COME OFF MACHINE

4.0	QC8	SECOND CHECK
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Comment: SECOND CHECK

07/04/26 (50)

5.0	PACKAGING 1	PACKAGING RESOURCE #1
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Comment: PACKAGING RESOURCE #1

Identify and Stock
 Location: NS

07/05/08 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes ☒ No ☐ DQA: PA Date: 07/05/08
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Wednesday, 4/4/2007 9:03:32 AM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BASKET HINGE

Job Number: 31608

Part Number: D22321

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

Lot 105108

Job Completion



Lot 105108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

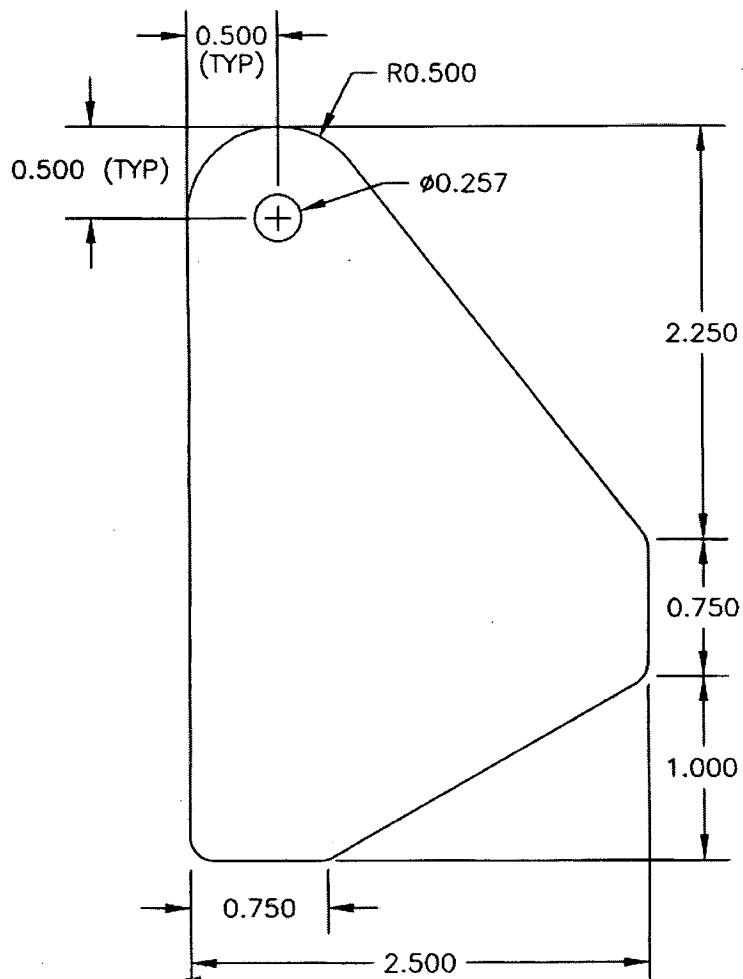
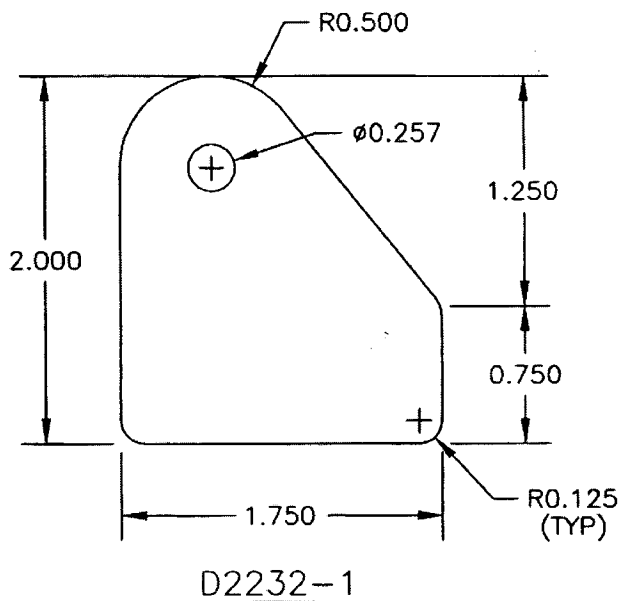
NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



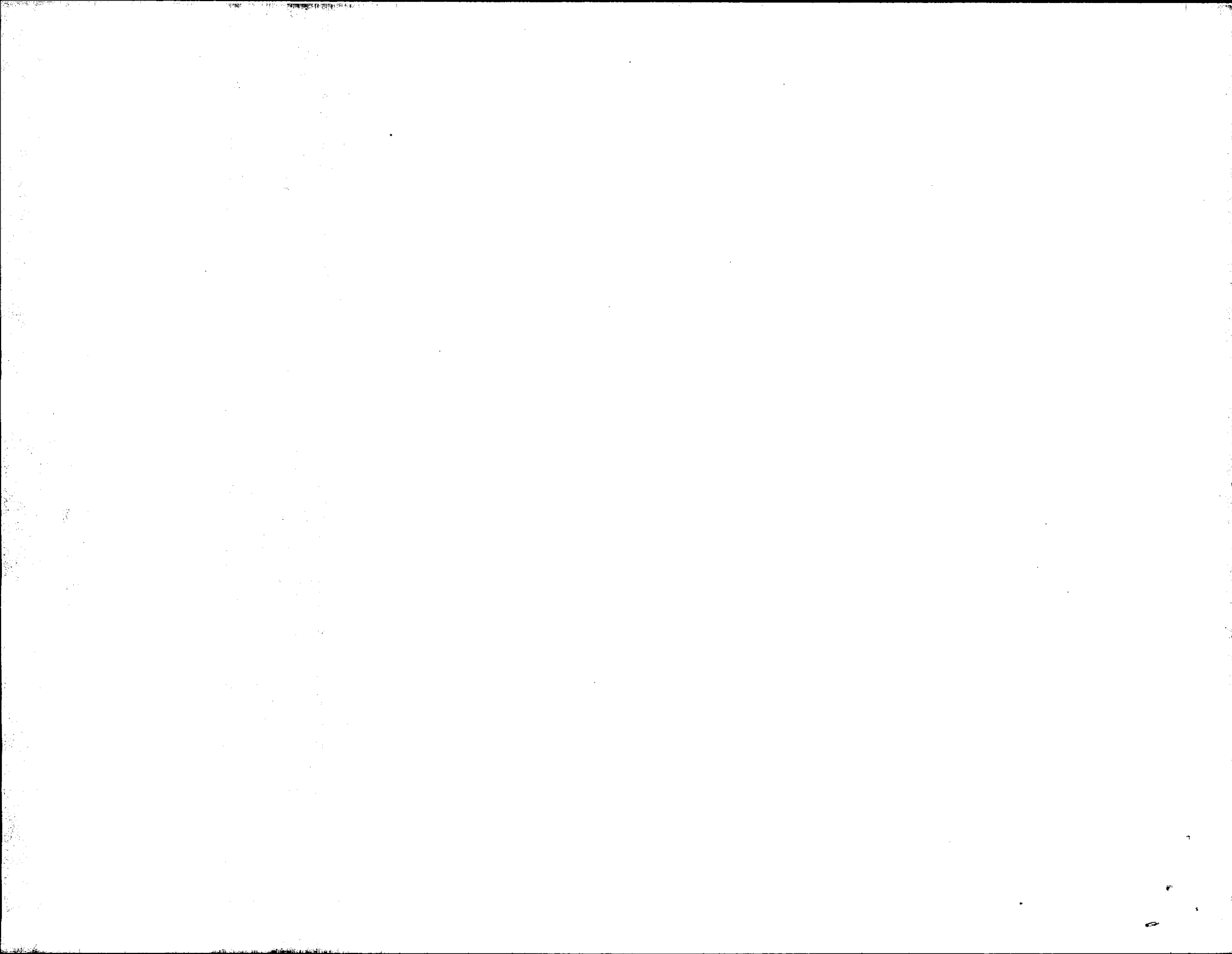
RELEASED
98.05.05 KE

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	REV. C
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2232	SHEET 1 OF 2
DATE 98.04.28	TITLE BASKET HINGE	SCALE 1:1	
A	94.05.12	NEW ISSUE	
B	96.01.02	ADDED -5 AND -7	
C	98.04.28	0.125 THICK WAS 0.063	



MATERIAL: AISI 304/316 SS 0.125 THICK

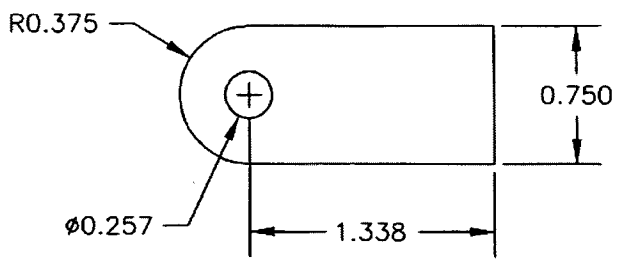
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 31608



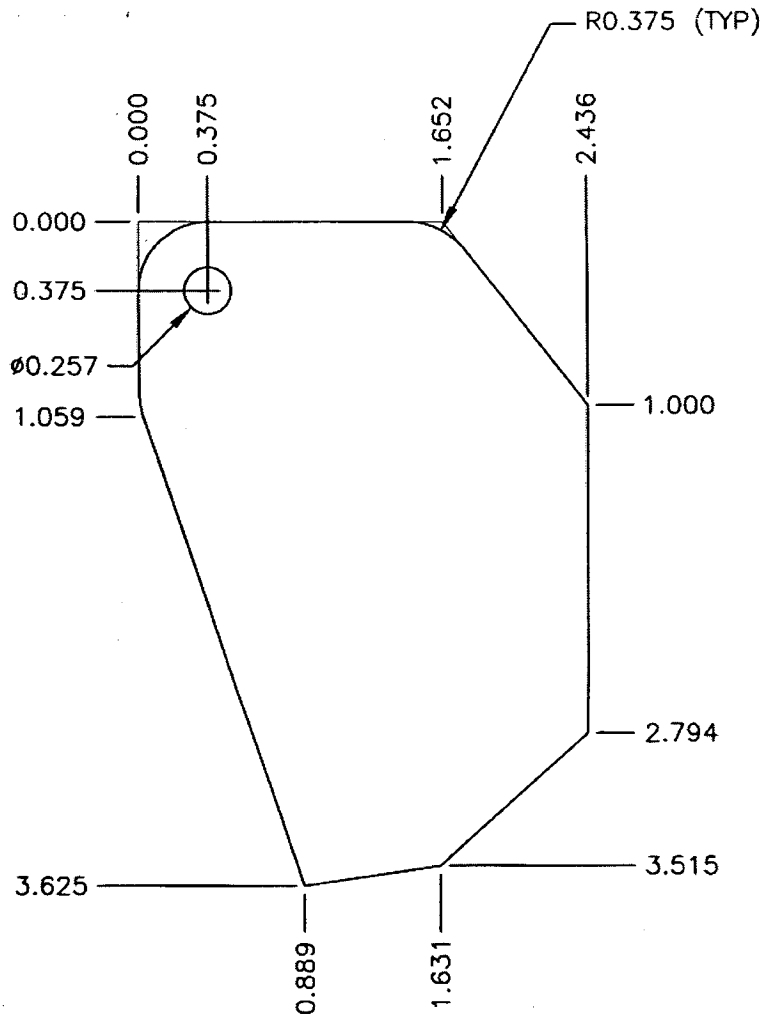


DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED	APPROVED	DRAWING NO.	REV. C
DATE		D2232	SHEET 2 OF 2
98.04.28		TITLE	SCALE
		BASKET HINGE	1:1

RELEASED
98.05.05 KE



D2232-7



D2232-5

MATERIAL: AISI 304/316 SS 0.125 THICK

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WITHOUT NOTICE
WORK ORDER
NO 31608

DART AEROSPACE LTD		Work Order: 31608
Description: Basket Hinge		Part Number: D2232-1
Inspection Dwg: D2232 Rev: C		Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Inspection Sheet Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
A $\phi 0.257$	$+0.006-0.001$	0.257	✓		VERN	
B 1.750	± 0.010	1.755	✓		VERN	
C 0.750	± 0.010	0.750	✓		VERN	
D 2.000	± 0.010	2.000	✓		VERN	
E R0.125	± 0.010	R0.125	✓		Radius Gauge	
F R0.500	± 0.010	R0.500	✓		Radius Gauge	
G 1.250	± 0.010	1.250	✓		Height Gauge	
H						
I						
J						
K						
L						
M						
N						
O						
P						
Q						
R						
S						
T						
U						
V						
W						
X						
Y						

Measured by: <i>MM. MM</i>	Audited by: <i>DA</i>	Prototype Approval:	N/A
Date: 07.04.25	Date: 07/04/25	Date:	N/A
Rev	Date	Change	Revised by KJ/RF
		New Issue	Approved

